

Work Order ID 52192

September 17, 2009 1:14:59 PM

Page 1

Item ID: D3943-7

Revision ID: A

Item Name: Stud

Start Date: 09/17/2009 Start Qty: 4.00

Required Date: 09/21/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: *mf* Date: *09-09-17* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

0.00

FOLIO REV: _____

DWG REV: _____

DJP 09/09/25

2-DEBURR AS REQUIRED

*****TAP DRILL FOR 1/4"-28 IN CENTER OF PART*****

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

DJP 09/09/25

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

UL

09/09/25

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 139

0.00



Packaging

Memo

0.00

Packaging

09/09/28 (4)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/28

U 09-28

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NOTE: Date & initial all entries

Picklist Print

September 17, 2009 1:14:58 PM

Page 1

Work Order ID: 52192



Parent Item: D3943-7RevA



Parent Item Name: Stud



Start Date: 09/17/2009

Required Date: 09/21/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010R0.375 		Purchased	No			100	f	0.0000	0.0800 			
ROUND BAR .375												

110860 0.0800 DIT 09/18/25

W/O:		WORK ORDER CHANGES					
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ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN4-10A	BOLT	
32	1			AN960-416	WASHER	
33	1			MS21042-4	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
41	1			S-1475	SPRING	REID SUPPLY
42	1			3408A59	BALL PLUNGER	McMASTER CARR
43	3			HX-15	SOCKET HEAD CAP SCREW 1/4-20 UNC X 0.75 LG	HASKINS

52192

RELEASED
09/05/13

A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. A
CHECKED		D3943	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.		DATE 09.05.13	
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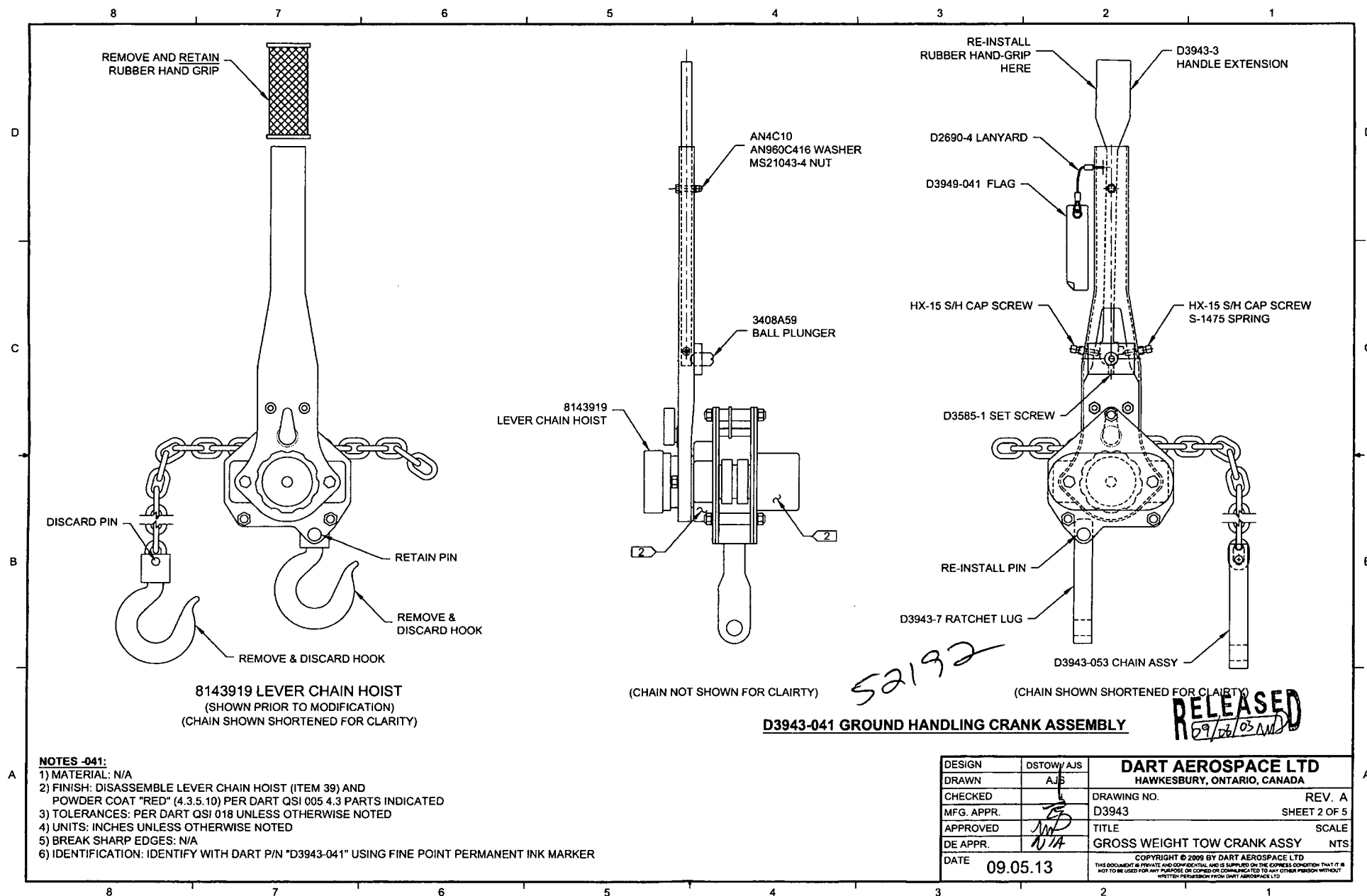
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NOTE: Date & initial all entries

D3943-1 HANDLE

2 PL

9.75

2.00

0.41

Ø0.30
THRU

Ø0.12
THRU

D3943-7 STUD
2 PL

THREAD $\frac{1}{4}$ -20 UNC-2B
2 PL

THREAD $\frac{1}{4}$ -20 UNC-2B
THRU

VIEW A-A
A5-3
(SCALE 2X) B5-3

2 PL

9.37

A B1-3

A B1-3

D3943-5 PLATE

D3943-051 HANDLE ASSEMBLY

NOTES -051:

- 1) MATERIAL : N/A
- 2) FINISH: POWDER COAT "RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: X.XX DIMENSIONS +/- 0.06 ALL OTHERS
PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) MASK ALL THREADS PRIOR TO POWDER COATING

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. A
CHECKED		D3943	SHEET 3 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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52192
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06/03/13

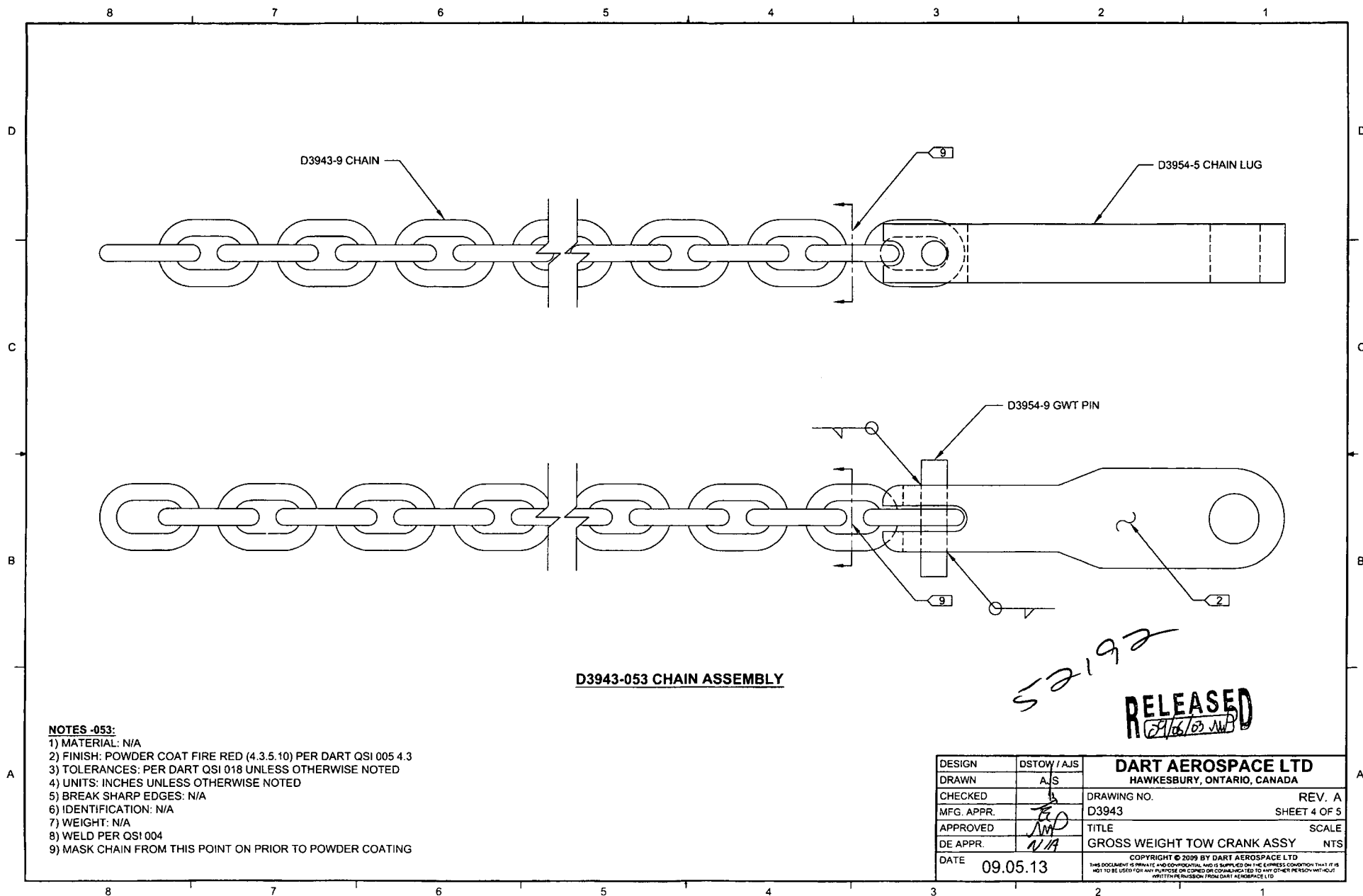
W/O:		WORK ORDER CHANGES					
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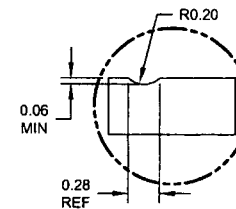
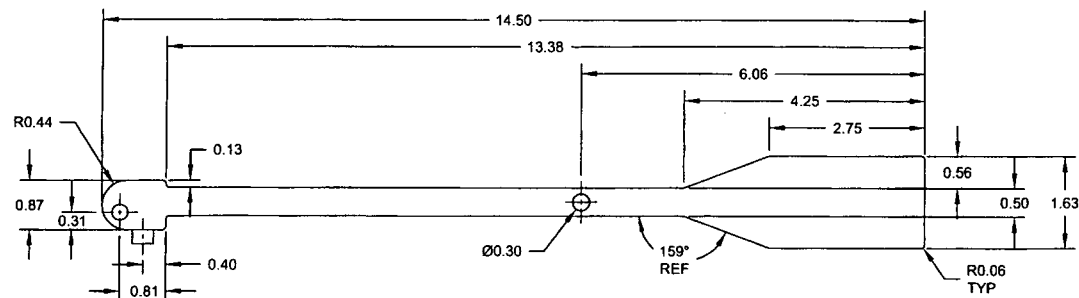
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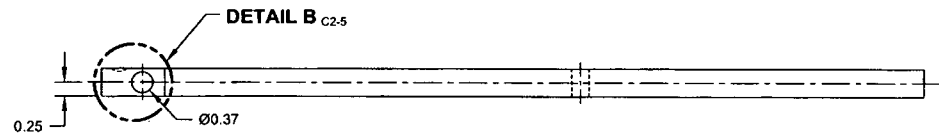
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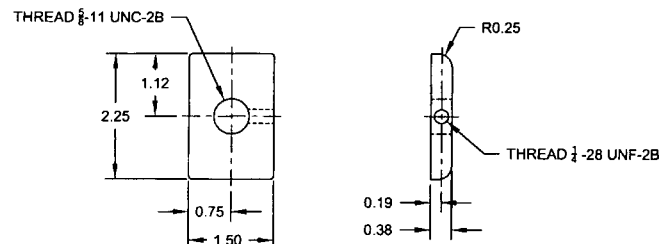
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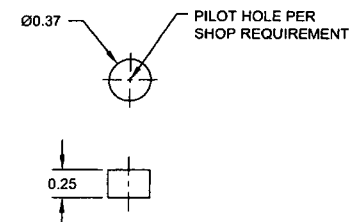
DETAIL B-B
(Dimple Detail)
(SCALE 2X)



D3943-3 HANDLE EXTENSION



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

RELEASED
9/16/09

52192

NOTES -11/-13:

- 1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S
- OR: MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B
- 7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

- 2) FINISH -3: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 PARTS INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
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MFG. APPR.	AS	D3943	SHEET 5 OF 5
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8 7 6 5 4 3 2 1

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